

# Work Order ID 86583

July-05-12 1:13:51 PM

**\*86583\***

Page 1

Item ID: **D2989-041** Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Basket Lid Assembly  
 Start Date: 7/05/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 7/27/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: C2 Date: 12/07/05 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								
100	Large Fab	0.00							
<b>*100*</b>									
Large Fab	Memo	0.00							
Large Fab	1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989								
	2- tack weld mesh on basket as per dwg D2989 using DT9445 jig								
	****cut cutouts with zip cut as per dwg D3832****								
	3- remove from jig and weld lable plate as per dwg D2989								
	A/R ER316 S.S. Rod Batch: <u>M122130</u>								
	<b>*** PLEASE NOTE ***</b>								
	IF MAKING -043A								
	ENSURE I X D3836-041 HAS NO BUSHING AND HAS HOLES PER								
	DSI9473								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

*1x*  
*Cpl 12.12.17*

*D4*  
*23*  
*12.12.18*  
*18*  
*08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00 0.00	<i>DAS</i> <i>15</i> <i>2-89</i>	<i>DAS</i> <i>09</i> <i>2-89</i>		<u>1</u>			
125 <b>*125*</b> HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo	0.00 0.00				<u>1</u>	<i>MB</i>	<u>12/2/18</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 Item Name: Basket Lid Assembly  
 Start Date: 7/05/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 7/27/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel  Memo 1- Plug holes prior to powder coating  2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989  1ST COAT: START TIME: 1:00 OVEN TEMPERATURE: 400°F FINISH TIME: 1:30 ***** 2nd coat if necessary ***** 2ND COAT: START TIME: 2:00 OVEN TEMPERATURE: 400°F FINISH TIME: 2:30  120509	0.00  0.00				1X	φ		Mk 12/12/18
131 *131* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 120509  Memo Mask lid prior to spray paint black and wing walk as per dwg A/R Spray paint black batch: 119945.	0.00				1	φ		12/12-19

WU 23383

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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 Required Date: 7/27/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
141	Identify as per dwg & Stock Location <b>358607 043</b>	0.00							
<b>*141*</b>									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

MF  
12-12-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 86583  
 Parent Item: D2989-041  
 Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12  
 Start Qty: 1.00

Required Date: 7/27/12  
 Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM  
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC  
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M 10-09-14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>D2221-1</b> Rib		Manufactured	No			100	Each	8.0000	2	2		24 8-09/12.12.12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		8							
				83907		8							
<b>D2506</b> Label Plate		Manufactured	No			100	Each	12.0000	1	1		24 8-09/12.12.12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA006		12							
				79197		1							
				82705		11							
<b>D2512-7</b> Rib		Manufactured	No			100	Each	8.0000	1	1		24 8-09/12.12.12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		8							
				53444		0							
				77522		4							
				81048		4							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 86583  
 Parent Item: D2989-041  
 Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12  
 Start Qty: 1.00

Required Date: 7/27/12  
 Required Qty: 1.00

D2581  
 Mounting Bracket

Manufactured No

100 Each 61.0000 2 2

DAS 24 8-8 12-12-12  
 392871 → ②

Location	Loc Qty	Loc Code
WA	39	
82506	2	
83230	3	
85436	10	
85452	24	
WA005	22	
70766	2	
81253	1	
82897	19	

D2989-13  
 Rib

Manufactured No

100 Each 4.0000 2 2

DAS 24 8-8 12-12-12  
 386971 → ②

Location	Loc Qty	Loc Code
WA	4	
84604	4	

D2989-19  
 Rib

Manufactured No

100 Each 10.0000 2 2

DAS 24 8-8 12-12-12  
 387650 → ②

Location	Loc Qty	Loc Code
WA	10	
77519	4	
84603	6	

D3832-3  
 Mesh (Lid)

Manufactured No

100 Each 1.0000 1 1

DAS 24 8-8 12-12-12  
 386576 → ①

Location	Loc Qty	Loc Code
WA035	1	
77520	1	

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 86583

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 7/27/12

Start Qty: 1.00

Required Qty: 1.00

D3833-3  
Mesh (Lid End)

Manufactured No

100 Each 13.0000 2 2

DAS 24 12-12-12

Location Loc Qty Loc Code

WA 4

81142 4

WA035 9

67460 9

B87412 → ①

B87413 → ①

D3836-041

Rib Assembly (Basket Lid, LH)

Manufactured No

100 Each 4.0000 1 1

DAS 24 12-12-12

Location Loc Qty Loc Code

WA 4

77515 4

B89446 → ①

D3836-042

Rib Assembly (Basket Lid, RH)

Manufactured No

100 Each 4.0000 1 1

DAS 24 12-12-12

Location Loc Qty Loc Code

WA005 4

77514 4

B89245 → ①

D3852-041

Rib Assembly

Manufactured No

100 Each 6.0000 1 1

DAS 24 12-12-12

Location Loc Qty Loc Code

WA005 6

77512 2

86042 2

86154 2

B87906 → ①

D3852-042

Rib Assembly

Manufactured No

100 Each 5.0000 1 1

DAS 24 12-12-12

Location Loc Qty Loc Code

WA 1

77513 1

WA005 4

66089 1

77513 1

86043 2

B87905 → ①

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

△ D

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

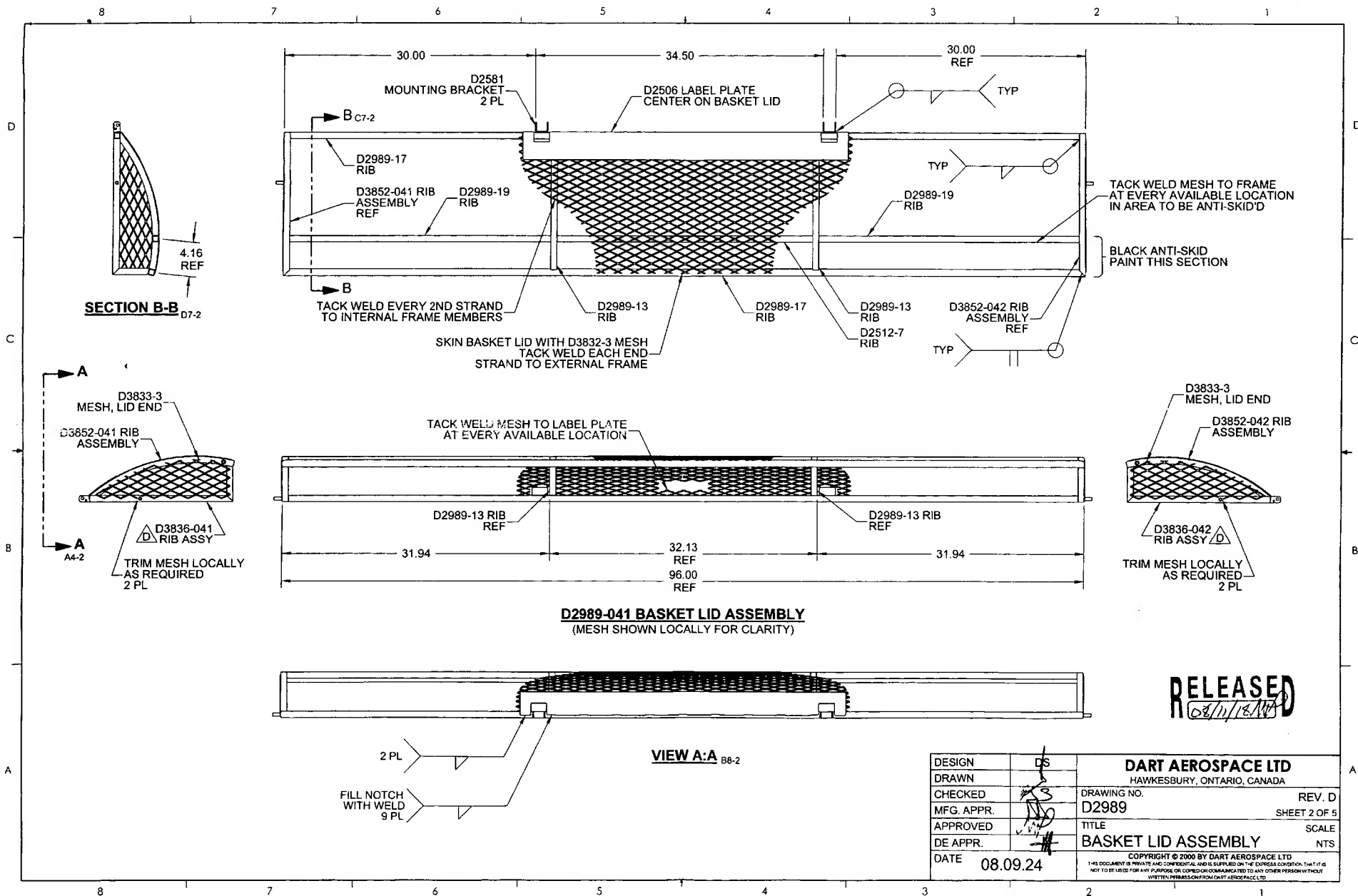
RELEASED  
08/11/18

CL 12/07/05  
WIO: 86383

**NOTES:**

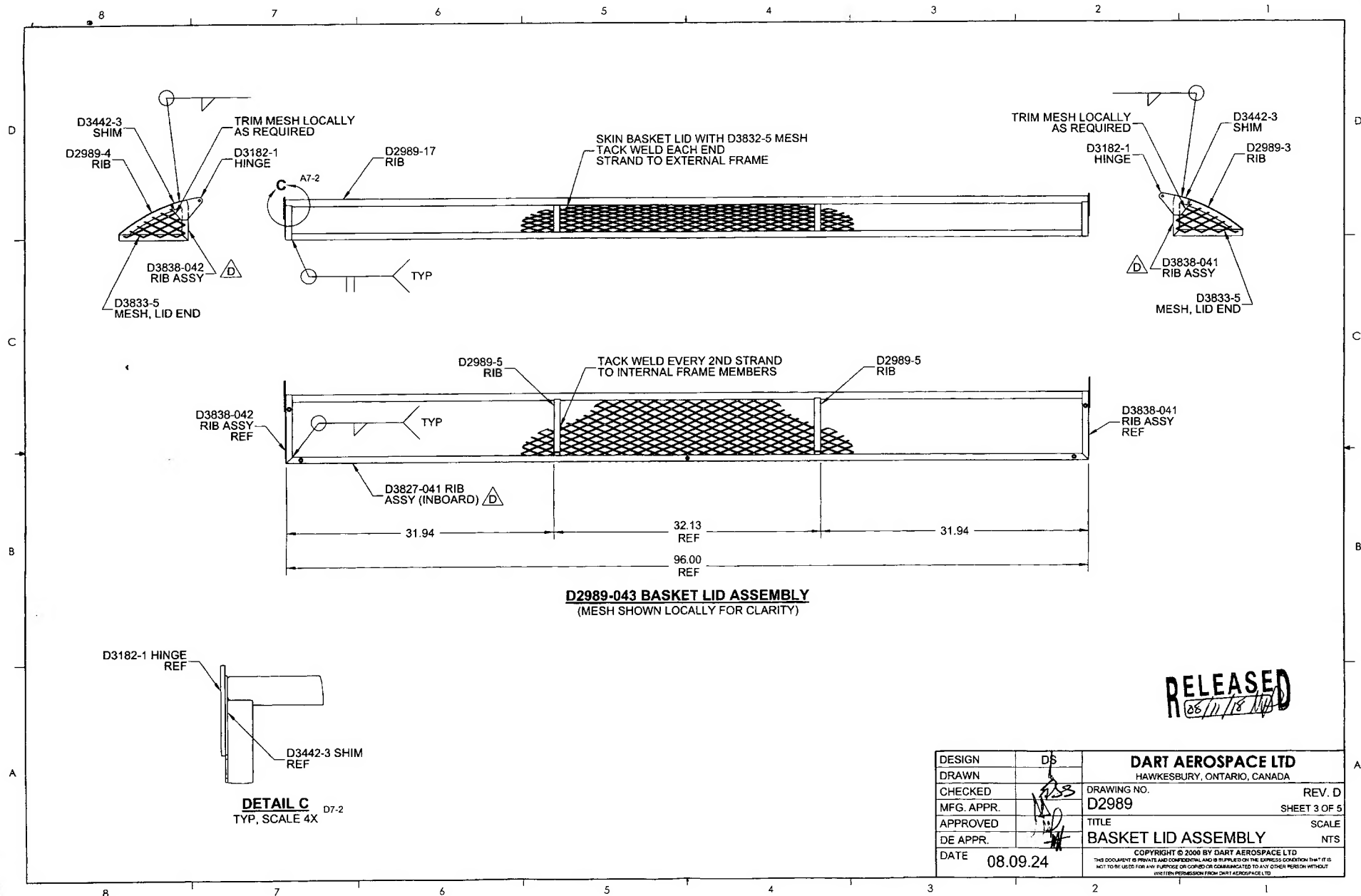
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

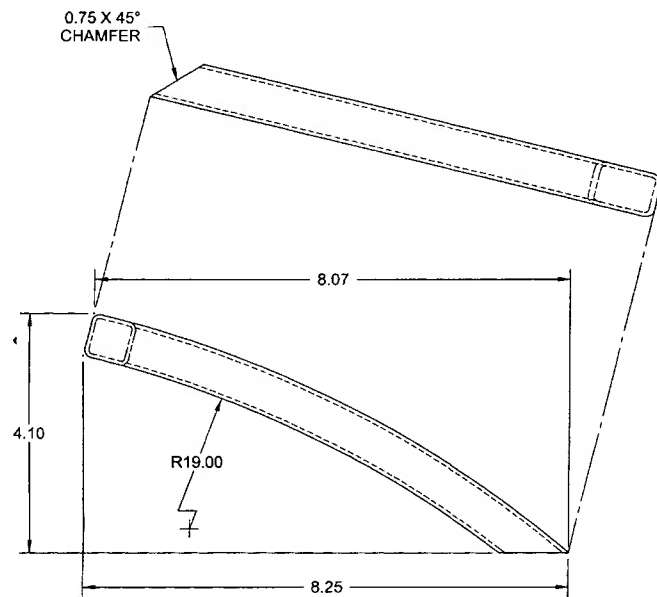
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-17; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	CS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		



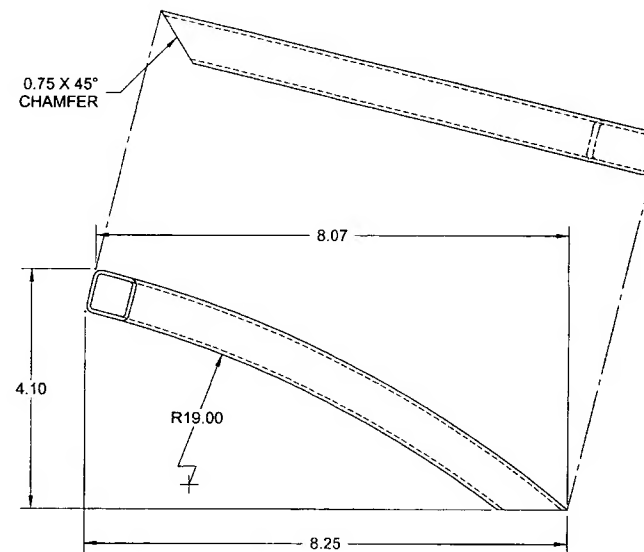
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	DD	D2989	SHEET 2 OF 5
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	BASKET LID ASSEMBLY	NTS
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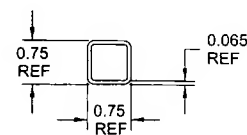




**D2989-3 RIB**



**D2989-4 RIB**

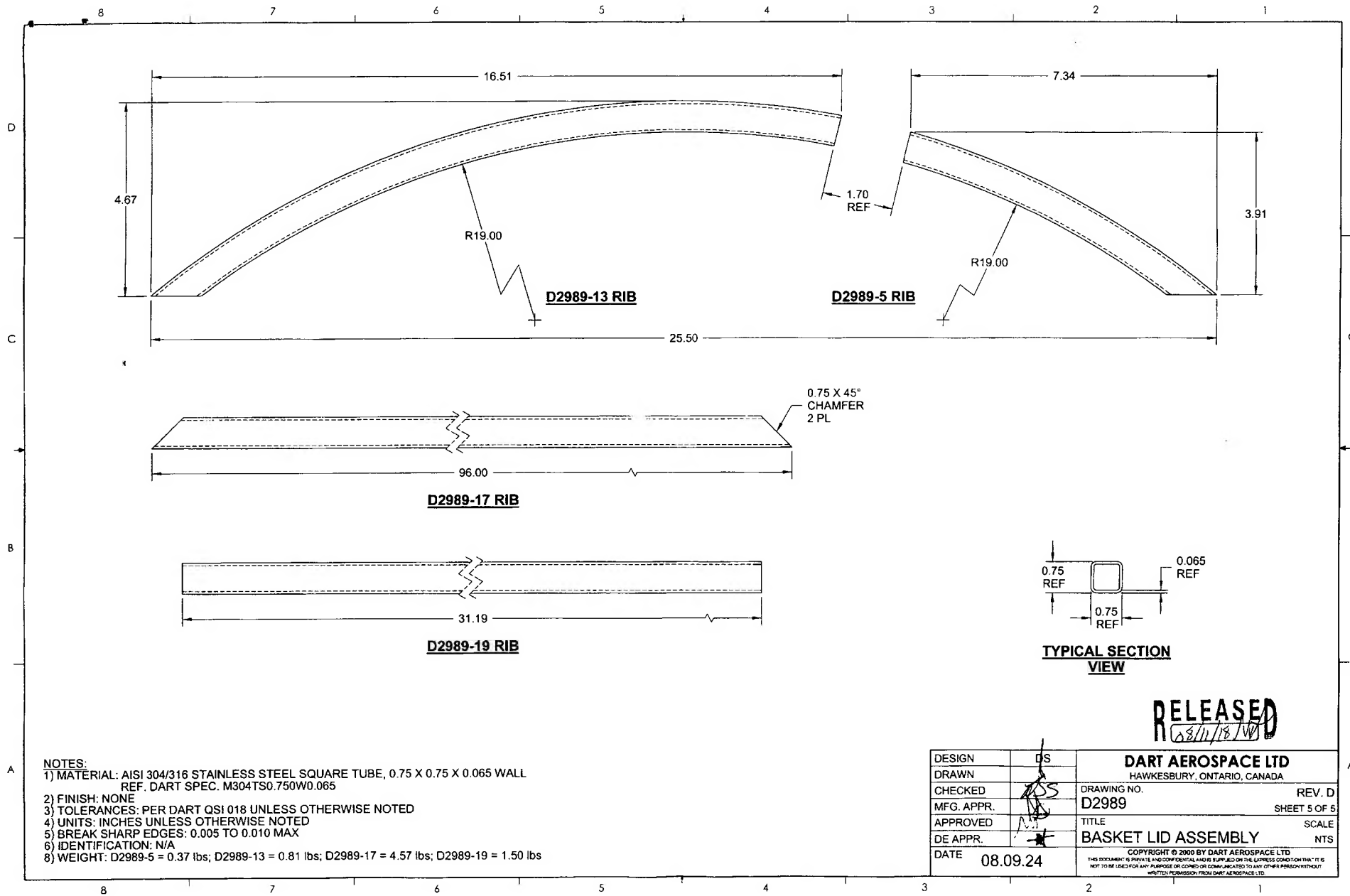


**TYPICAL SECTION  
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;




**RELEASED**  
08/11/18/11/18

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2989</b>	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET LID ASSEMBLY</b>	NTS
DATE	08.09.24	<small>           COPYRIGHT © 2000 BY DART AEROSPACE LTD            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS            NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT            WRITTEN PERMISSION FROM DART AEROSPACE LTD         </small>	



# NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D2989</b>	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET LID ASSEMBLY</b>	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			